



Dart Aerospace Ltd.
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RB910-0003
Job Sheet 194986



Part No: RB910-0003

Job Qty: 1 pcs

Part Name: Tail Rotor Gearbox Drain Hose (Bell 430)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 7/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP Rev A 17.11.08 New issue DP Verify DD

Ship Via:

order 16285

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	7/8/19		0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	7/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
130	Packaging 3-1 - Stock - B4B	1 pcs	7/8/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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Container No: S187652



Part: RB910-0003

Job No: 194986

Serial No/Batch: S187652

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 06/05/19

JUN 05 2019 40 9-89

					Packaging 3 - 8 - B4B					
					Packaging 3 - 9 - B4B					
					Packaging 3 - 10 - B4B					
					Packaging 3 - 11 - B4B					
					Packaging 3 - 12 - B4B					
					Packaging 3 - 13 - B4B					
					Packaging 3 - 14 - B4B					
					Packaging 3 - 15 - B4B					
					Packaging 3 - 16 - B4B					
					Packaging 3 - 17 - B4B					
					Packaging 3 - 18 - B4B					
					Packaging 3 - 19 - B4B					
					Packaging 3 - 20 - B4B					
					Packaging 3 - 21 - B4B					
					Packaging 3 - 22 - B4B					
					Packaging 3 - 23 - B4B					
					Packaging 3 - 24 - B4B					
					Packaging 3 - 25 - B4B					
					Packaging 3 - 26 - B4B					
					Packaging 3 - 27 - B4B					
					Packaging 3 - 28 - B4B					
					Packaging 3 - 29 - B4B					
					Packaging 3 - 30 - B4B					
					Packaging 3 - 31 - B4B					
					Packaging 3 - 32 - B4B					
					Packaging 3 - 33 - B4B					
					Packaging 3 - 34 - B4B					
					Packaging 3 - 35 - B4B					
					Packaging 3 - 36 - B4B					
					140 QC 21 - SA	1 pcs	7/8/19	0.00 0.00	QC 21 - SA - 21	120M
									QC 21 - SA - 70	DAC 21
									QC 21 - SA - 53	2.00 JUN 05 2010

120M

DAS
21
3-89 JUN 05 2019

GA076

Part Op 110 - (Small Fab) - Assemble as per DWG. Sheet 1 Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one Description: end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T47	Tube Ø1.09	.3300 ft (.33 ea)	110-Small Fab - 1	5142226
2044T67	Cap Ø1.09	2 Ea (2 ea)	110-Small Fab - 1	5172639
51495K116	COUPLING 1/2" NCKL PLTD BRASS	1 Ea (1 ea)	110-Small Fab - 1	5093263
9263K642	O-Ring	1 Ea (1 ea)	110-Small Fab - 1	5078377
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	6 ft (6 ea)	110-Small Fab - 1	5156086
M304TR0.375W.065	304 Round Tube .375 X .065W	.8300 ft (.83 ea)	110-Small Fab - 1	5177278
PAD210	Foam Ø1 X 1 replace item 1887T48	.0070 sf (.007 ea)	110-Small Fab - 1	5021250
RB910-0003-1	Quill	1 pcs (1 ea)	110-Small Fab - 1	5018792

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	2044T47	0	53	0
	2044T67	2	260	0
	51495K116	1	71	0
	9263K642	1	48	0
	K010-0608	6	527	0
	M304TR0.375W.065	1	31	0
	PAD210	0	1	0
	RB910-0003-1	1	2	0

Part Specifications

Specifications could not be found.

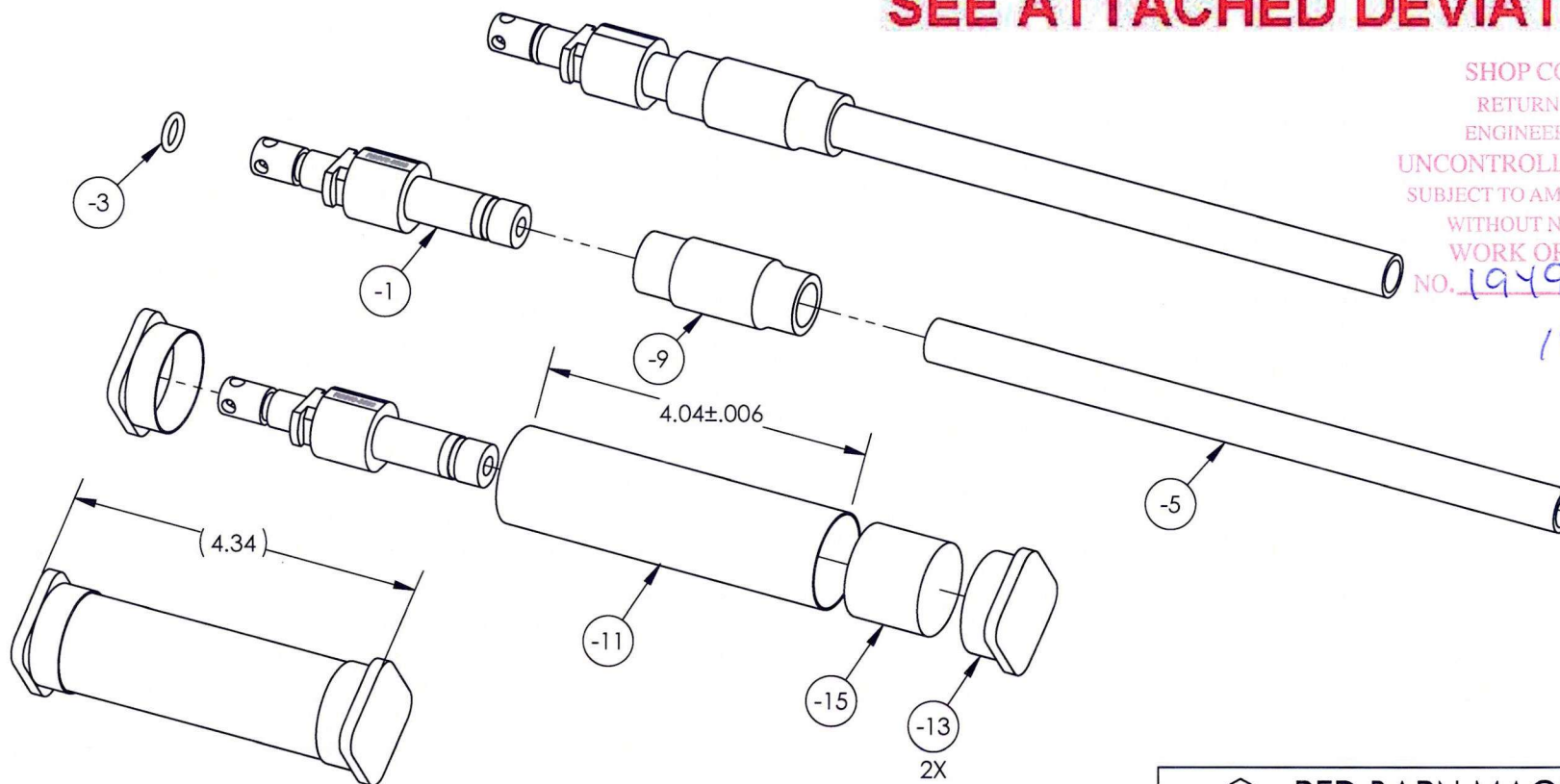
Plex 5/13/19 8:51 AM Dart.lajeunesse.marie

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	SHORTENED LATCH FROM .125 TO .100	9/12/06	WP	
2	CHANGED P/N FROM HF090806, & ADDED FLAT FOR P/N	9/21/06	WP	
3	IMPEMENTED NEW DWG. FORMAT. CONDENSED DIMS., AND ADDED ASSEMBLY VIEW. ALSO REDUCED -1 FROM THREE HOSE RIBS TO ONE.	5/20/08	WP	
4	CH'D -1 CALL OUT FROM MILL A .188 FLAT FOR P/N .081 TEXT PER G.E.	7/27/11	RJC	
5	-1 MODIFIED TO USE -9 COUPLING, ADDED -9, -11, -13, -15 TO BOM. CH'D DIM ON FLATS WAS .188 IS (2X .20 MIN). CH'D HOLE WAS $\varnothing .25 \sqrt{1.98}$ IS $\varnothing .22$ THRU. ADDED (1.285) DIM. CH'D LATCH WIDTH WAS .432 IS .436. CH'D DIMS ON A-A WAS .100 X 45° IS 2X 45° DELETED .617, -7 DELETED.	1/24/2014	DPD	GE

SEE ATTACHED DEVIATION

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194986 MJS
190513



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	QUILL	6061	$\varnothing 1 \times 3-1/2$	2
		B/O	-3	1	O-RING	VITON	2-011N70 OR MCMaster-CARR #9263K642	1
		B/O	-5	1	HOSE	VINYL	$\varnothing 1/2$ O.D. x $\varnothing 3/8$ I.D. x 6ft KURI-TECH #K010-0608	1
		B/O	-9	1	COUPLING	NICKEL-PLATED BRASS	$\varnothing 1/2$ MCMaster-CARR #51495K116	1
		B/O	-11	1	TUBE	POLYETHYLENE	$\varnothing 1.09$ MCMaster-CARR #2044T47	1
		B/O	-13	2	CAP	VINYL	$\varnothing 1.09$ MCMaster-CARR #2044T67	1
		B/O	-15	1	FOAM	POLYESTER/POLYURETHANE	$\varnothing 1 \times 1$ NEW PIG CORP. #PAD210	1

RED BARN MACHINE	
TITLE T/R GEARBOX DRAIN TOOL	
DWG NO. RB910-0003	REV 5
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED: D Weil HEAT TREAT FINISH SPEC USED ON MODEL BELL 430	
SCALE 1:2	DATE 9/7/2006
SHEET 1 OF 2	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details: _____ 			